FIG 1 Apply foamable plastic layer containing a foaming agent over a sheet substrate. Heat to gel the plastic layer without activating the foaming agent Apply a first printing ink containing a photoinitiator and an expansion inhibitor in a first pattern on the gelled plastic layer Apply a clear non curable coating over the gelled plastic layer and first printing ink Apply a dear curable coating over the non curable coating Gel the curable coating by heating Soften the gelled curable coating by heating Mechanically emboss the softened curable coating with a textured roll such as that imitating the texture of grout or mortar Expose the cureble ocating to UV light to set the texture in those portions of the coating overlying the first

Fuse the product in a fusion oven by heating. That portion of the curable coating which does not overlie the printing inks containing a photoinitiator smooths out

and second printing containing a photoinitiator

Optionally mechanically emboss the surface of the curable coating which has smoothed out with a texture imitating the texture of stone, wood, or the like

Cure that portion of the curable coating which overlie unprinted areas





